

Date: Tuesday, 03/04/2007 11:02:08 AM  
 User: Linda Lacelle

## Process Sheet

*Spcl*  
*SB 07/07/09*

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SET SCREW
Job Number	: 31571-4	Part Number	: D35851
Estimate Number	: 12804	Drawing Number	: D3585 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 03/04/2007	Drawing Revision	: A
Prsh Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 10/04/2007
Previous Run	: 31384	Qty:	<i>30</i>
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-03-20 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 REMOVE FROM STOCK <i>D3585-1 B 31384</i>	<i>MF 07-04-09</i>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 DRILL HOLE PER DRWG D3585 REV.A	<i>MF 08-02-26 (30)</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>SB 08/02/26 30</i>
4.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 REIDENTIFY & STOCK USING NEW B/N	<i>ST/10 Pg/1/17 (30)</i>
5.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>D 08/02/27 (30)</i>

Job Completion



*u 08.02.27*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		split w/o . took 40 screw		MF	07-07			
		split w/o - took 4 screws		MF	07-07-17			
07-09- 10 07/07/22	2	Split w/o took 2 screws		MF	07-09- 10	2		
		split w/o		BB	07-10-22			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

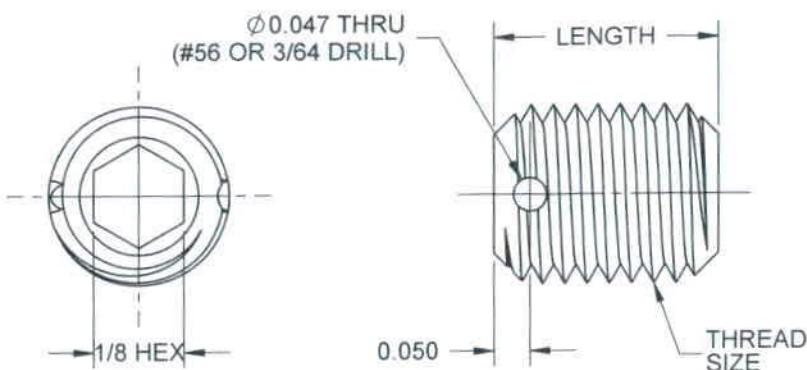
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

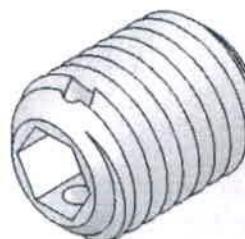
DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3585	REV. A	SHEET 1 OF 1
DATE 07.01.02			TITLE SET SCREW	SCALE NTS
REV A	DATE 07.01.02	DESCRIPTION NEW ISSUE		

## SPECIFICATION CONTROL DRAWING



P/N	THREAD SIZE	LENGTH	POSSIBLE SUPPLIER
D3585-1	1/4-28 UNF	0.313	McMASTER-CARR P/N 90289A352

*W/D 31571*

**NOTES:**

- 1) TYPE: KNULED CUP POINT SET SCREW
- 2) MATERIAL: BLACK-OXIDE ALLOY STEEL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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